

I Claim:

1. A method of forming a laminated substrate or base structure comprising the steps of:
forming separately a number of layers;
5 joining the layers together by warp knitted or stitch bonded binder yarns,
wherein at least one of the layers is a reinforcing layer and at least one of the layers is a layer for inhibiting flow-through of coatings to
10 be applied to one or both sides of the substrate or base structure.
2. The method of claim 1, wherein at least two of the layers are reinforcing layers separated
15 by a layer for inhibiting flow-through of coatings to be applied to one or both sides of the substrate or base structure.
3. The method of claim 1, wherein the binder
20 yarns form a matrix of loops above a surface of the substrate or base structure and serve as bonding points for anchoring the coatings applied thereto.
4. The method of claim 1, wherein at least
25 one of the layers and binder yarns has an adhesive affinity for at least one of the coatings.
5. The method of claim 3, wherein the matrix
30 of yarn loops improves the structural stability of the substrate or base structure.

6. The method of claim 1, including the step of coating only one side of the substrate or base structure.

5 7. The method of claim 1, including the step of coating both sides of the substrate or base structure.

8. The method of claim 1, including the step
10 of coating both sides of the substrate or base structure with the same coating.

9. The method of claim 1, including the step of coating at least one side of the substrate or
15 base structure with a rubber coating.

10. The method of claim 1, including the step of coating the substrate or base structure on a first side thereof with a first polymer type and
20 coating a second side thereof with a second polymer different than the first polymer.

11. The method of claim 1, including the step of forming the substrate or base structure in strips
25 of material which are ultimately spiral wound to form a base support structure having a width greater than a width of the strips.

12. The method of any of claims 6, 7, 8, 9 and
30 10, comprising the further step of forming a plurality of grooves on the non-shoe side surface of the coated substrate or base structure.

13. The method of any of claims 6, 7, 8, 9 and
10, comprising the further step of forming a
plurality of blind drilled holes on the surface of
5 the coated substrate or base structure.

14. The method of claim 1, including the step
of using the substrate or base structure as the
support structure of a long nip press or other
10 papermaking belt.

15. The method of claim 1, wherein at least
one reinforcing layer comprises multifilament or
monofilament yarns.
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16. The method of claim 1, wherein the flow-
inhibiting layer is made by one of spun bonded, wet
laid and air laid processes.

20 17. The method of claim 1, wherein the flow-
inhibiting layer is a nonwoven scrim, extruded mesh,
or extruded or cast porous or nonporous film.

18. The method of claim 1, wherein the coating
25 to be applied to the substrate or base structure is
polymeric or rubber.

19. A laminated substrate or base structure
comprising:
30 a number of separately formed layers;
said layers joined together by warp knitted or
stitch bonded yarns;

wherein at least one of the layers is a reinforcing layer and at least one of the layers is a layer for inhibiting flow-through of coatings to be applied to one or both sides of the substrate or
5 base structure.

20. The substrate or base structure of claim 19, wherein at least two of the layers are reinforcing layers separated by a layer for
10 inhibiting flow-through of coatings to be applied to one or both sides of the substrate or base structure.

21. The substrate or base structure of claim 19, wherein the binder yarns form a matrix of loops above a surface of said substrate or base structure and serve as bonding points for anchoring the
15 coatings to said substrate or base structure.

22. The substrate or base structure of claim 19, wherein at least one of the layers and binder yarns has an adhesive affinity for at least one of the coatings.
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23. The substrate or base structure of claim 21, wherein the matrix of yarn loops improves the structural integrity thereof.
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24. The substrate or base structure of claim 19, wherein only one side of the substrate or base structure is coated.
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25. The substrate or base structure of claim 19, wherein both sides of the substrate or base structure are coated.

5 26. The substrate or base structure of claim 19, wherein both sides of the substrate or base structure are coated with the same coating.

10 27. The substrate or base structure of claim 19, wherein the substrate or base structure is coated on a first side with a first polymeric type and coated on a second side with a second polymer different than the first polymer.

15 28. The substrate or base structure of claim 19, wherein the substrate or base structure is formed in strips of material which are ultimately spiral wound to form a base support structure having a width greater than a width of the strips.

20 29. The coated substrate or base substrate of any of claims 24, 25, 26 and 27, wherein the non-shoe side surface thereof includes a plurality of grooves.

25 30. The substrate or base substrate of any of claims 24, 25, 26 and 27, wherein a surface thereof includes a plurality of blind holes.

30 31. The substrate or base structure of claim 19, wherein the substrate or base structure is used

as the support structure of a long nip press or other papermaking belt.

32. The substrate or base structure of claim
5 19, wherein at least one reinforcing layer comprises multifilament or monofilament yarns.

33. The substrate or base structure of claim
10 19, wherein the flow-inhibiting layer is made by one of spun bonded, wet laid and air laid processes.

34. The substrate or base structure of claim
15 19, wherein the flow-inhibiting layer is a nonwoven scrim, extruded mesh, or extruded or cast porous or nonporous film.

35. The substrate or base structure of claim
20 19, wherein the resin to be applied to the substrate or base structure is polymeric or a rubber like compound.